

Work Order ID 62795

Friday, October 08, 2010 10:47:18 AM



Page 1

Item ID: D4073-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Hinge

Start Date: 10/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *M*

Date: *10-10-08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4073

A

100

Cut blanks as per folio

0.00



Bandsaw

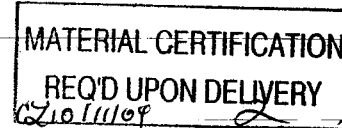
Memo

0.00

Jeaspa Bandsaw

cut blank 3.875" long

cut 10/11/02



105

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA939

Dwg Rev: *A*

Folio Rev: *A*

10/11/03

Deburr

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SH 10/11/03

2

0

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

OK 10/11/03

2

0

150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> JH 10/11/03

2 0

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo
M16524L START: 9:25.
OVERT: 3:20
FINISH: 9:55

0.00

Powder Coating

2 BL 10-11-4.

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

=> 2 10/11/04

2 d

180

Identify as per dwg & Stock Location: 122

0.00

Packaging

Memo

0.00

Packaging

10/11/4 SP 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Friday, October 08, 2010 10:47:18 AM



Page 4

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-11-08

U 10-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 10:47:23 AM

Page 1
/

Work Order ID: 62795

Parent Item: D4073-1

Parent Item Name: Door Hinge



Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	28.7889	0.3333333	0.666667			



6061-T6 Bar 2.00 x 1.25



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	28.7889	
→ 114507	16.7889	
114899	12	

666 mk 10/11/02

dB
114507
has been fixed

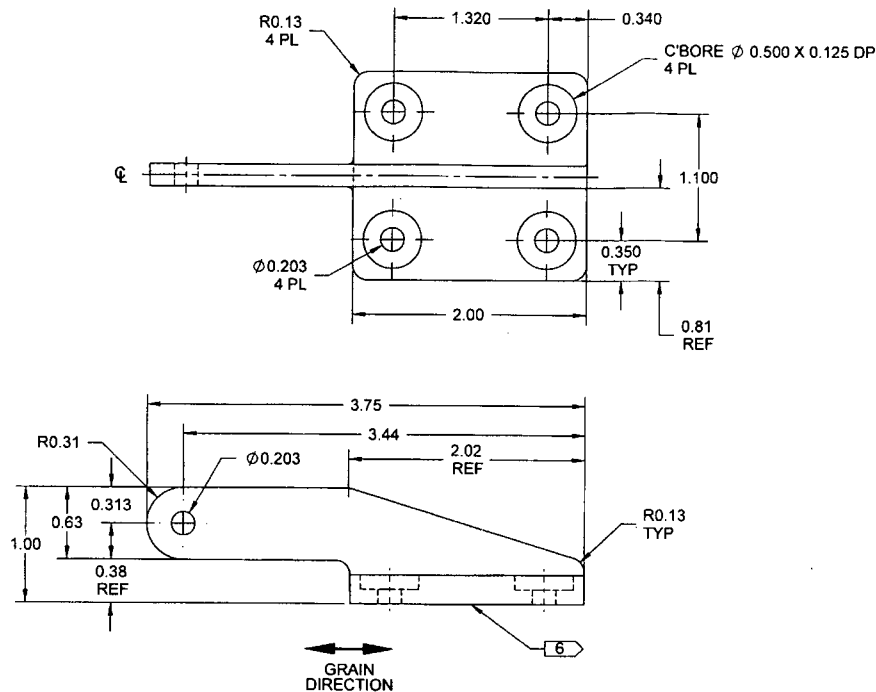
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NO. 62795
2/10/08

D4073-1 DOOR HINGE

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

A NEW ISSUE		RF		10.09.16
REV.	DESCRIPTION			DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	PORT HADLOCK, WA		
CHECKED	140	DRAWING NO.	REV. A	
MFG. APPR.	21	D4073	SHEET 1 OF 2	
APPROVED	140	TITLE	SCALE	
DE APPR.	140	DOOR HINGE	NTS	
DATE	10.09.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

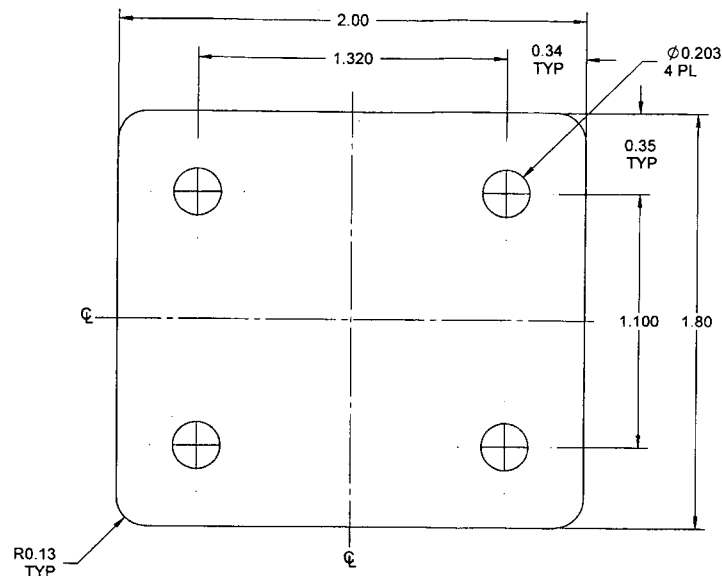
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WLO 42795



D4073-3 DOOR HINGE BACKING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

RELEASED
2010-09-23
ND

DESIGN	<i>RF</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>RF</i>	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4073	SHEET 2 OF 2
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	DOOR HINGE	NTS
DATE	10.09.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Magna Stainless
5775 Kieran St, Saint-Laurent QC H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 I0263

SOLD TO:

00003858
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

MTR: Y

INVOICE DATE:	04/28/10
ORDER DATE:	04/27/10
SHIP DATE:	04/28/10
ORDER NUMBER:	W028849
PURCHASE ORDER:	P011758

Currency	Sales Person	Ship Via	F.O.B.	Terms
CANADIAN DOLLARS	ERYCK BLAIS	NIR:R-557065-1	PREPAID	NET 30 DAYS

Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
		1	PC	ALUMINUM ANGLES AAN 6061 T6 4" x 4" x 1/4" x R/L L036000 20' 1 PC/46 LB	1 UN	105.00	105.0
		2	PC	ALUMINUM FLATS AFL 6061 T6 1-1/4" x 2" x R/L L037998 20' 2 PC/118 LB	2 UN	135.00	270.0

RECEIVED MAR 03 2010

04/29/10 13:17:24

PST Exmp No: EXEMPT

Merchandise:	375.00
Surcharges:	
No Tax Costs:	
GST	18.75
Total Due:	393.75

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1% per month.

OST # 121226471

DART AEROSPACE LTD		Work Order: 62795
Description: Door Hinge		Part Number: A4073-1
Inspection Dwg: A4073 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.320	±.010	1.321	/		Uel	SA-9
.340	±.010	.340	/			
Ø.503 X .125 Dia	±.010	Ø.503 X .126	/			
1.100	±.010	1.100	/			
.350	±.010	.350	/			
.81	±.030	.803	/			
2.00	±.030	1.999	/			
Ø.203	±.006	Ø.205	/			
3.75	±.030	3.750	/			
3.44	±.030	3.439	/			
1.00	±.030	.970	/			
.63	±.030	.614	/			
.313	±.010	.3125	/			
.38	±.030	.380	/			
R.13 Lp	±.030	R.125	/			
.190	±.030	.190	/			
.25	±.030	.245	/			
1.80	±.030	1.800	/			

Measured by: SA	Audited by: [Signature]	Preliminary Approval: N/A
Date: 10/11/03	Date: 10/11/03	Date: -

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

325 rue Avro
Pointe-Claire, QC, Canada, H9R 5W3
Téléphone (514) 697-5120
Fac-simile (514) 694-8310

sapa:

Test de dureté Rockwell Rockwell Hardness Test

Client / Customer : **MAGNA STAINLESS INC.**

Adresse / Address : **5775 RUE KIERAN
SAINT LAURENT, QUEBEC
H4S 0A3**

commande Sapa/ Sapa order # : **32161**

bon de commande / Purchase order # : **P009572**

de matrice / Die # : **MS 16382**

Description : **2" X 1 1/4" FLAT BAR**

Alliage & trempage / Alloy & temper : **6061 T6**

Customer Part # : **N/A**

Contrôle / Control # : **16661-1**

Coulée / Cast # : **47825**

Dureté Rockwell E /
Rockwell E hardness : **92 HRE**

Min. requis /
Min. required : **88 HRE**

Max. permis /
Max. permitted : **100 HRE**

Composition chimique typique / Typical chemical composition :

Alliage/Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,66 - 0,74	0,14 - 0,28	0,08 - 0,16	0,18 - 0,26	0,46 - 0,54	0,03 Max	0,05 Max	0,05 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	---	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et **AMS QQA 200/8** excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and **AMS QQA 200/8** except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,
Yours truly,

date : **2010-04-06**

Michel Lefebvre

Michel Lefebvre
Technicien de la qualité
Quality technician

C 2782

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	ALS4-1032-130 / Insert	Main Warehouse ST282	61220	QUIR01		197.0000		159.0000		
		Main Warehouse ST282	61586	QUIR01	8/11/10	-16.0000	114407	-16.0000		-\$2.08
		Main Warehouse ST282	53062	LAVO01	9/03/10	-16.0000	114407	-16.0000		-\$2.08
		Main Warehouse ST282	61888	DESJ02	9/13/10	-10.0000	114407	-10.0000		-\$1.30
		Main Warehouse ST282			9/14/10	-17.0000	114407	-17.0000		-\$2.21
								-1,648.0000		-\$214.24
	M6061T6B2.000X01.250 / 6061-T6 Bar 2.00 x 1.25	Main Warehouse MAT	57925	DCUSER		40.0000		40.0000		
		Main Warehouse MAT	57924	FAUT01	5/18/10	-10.9200	114407	-10.9200		-\$83.96
		Main Warehouse MAT	59612	FAUT01	6/10/10	-10.4000	114407	-10.4000		-\$79.96
		Main Warehouse MAT	61525	DCUSER	6/14/10	-0.3333	114407	-0.3333		-\$2.56
		Main Warehouse MAT	61529	DCUSER	9/13/10	-0.7789	114407	-0.7789		-\$5.99
		Main Warehouse MAT	62795	DCUSER	9/13/10	-0.7789	114407	-0.7789		-\$5.99
		Main Warehouse MAT	62914	DCUSER	11/02/10	-0.6667	114407	-0.6667		-\$5.13
		Main Warehouse MAT			11/02/10	-0.6667	114407	-0.6667		-\$5.13
								-24.5445		-\$188.72

B/N should read 114507